

Date: Wednesday, 10/11/2006 12:50:31 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BRACKET		
Job Number	: 28942					
Estimate Number	: 11140					
P.O. Number	: N/A			Part Number	: D32053	
This Issue	: 10/11/2006		S.O. No. : N/A	Drawing Number	: D3205 REV A	
Prsh Rev.	: NC			Project Number	: N/A	
First Issue	: N/A		Type : MACHINED PARTS	Drawing Revision	: A	
Previous Run	: 26001			Material	: N/A	
Written By	:			Due Date	: 10/30/2006	
Checked & Approved By	:			Qty:	8 Um: Each	
Comment	: Est B 05/01/31 Revised Step 10 KJ/JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B0250X02000	6061-T6 Bar .25" X 2.0"	
		Comment: Qty.: 0.2284 f(s)/Unit Total : 1.8270 f(s) 6061-T6 Bar .25" X 2.0" Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11 or QQ-A-225/8)(M6061T6B0.250x02.000) Identify for D3205-3 Batch: M15949 J.F. 06/10/22 S	
2.0	BAND SAW	BAND SAW	
		Comment: BAND SAW Cut blanks: 2.00" x 0.250" x 2.480" long Bar (+0.030/-0.000)	J.F. 06/10/22 8
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Machine D3205-3 as per Folio FA343 and Dwg D3205 Identify as D3205-3 Deburr and Tumble	J.F. 06/10/22 8
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	J.F. 06/10/22 8
5.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	S 06.10.22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/18/25
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 28942

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

YL

06/10/25 X8

7.0 POWDER COATING

POWDER COATING



M19720

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

YL

06/10/26 X8

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

LB 06/10/26 (8)

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock.

Location: ST414

B 06/10/26 (8)

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/10/26

Job Completion



Loc 10126

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

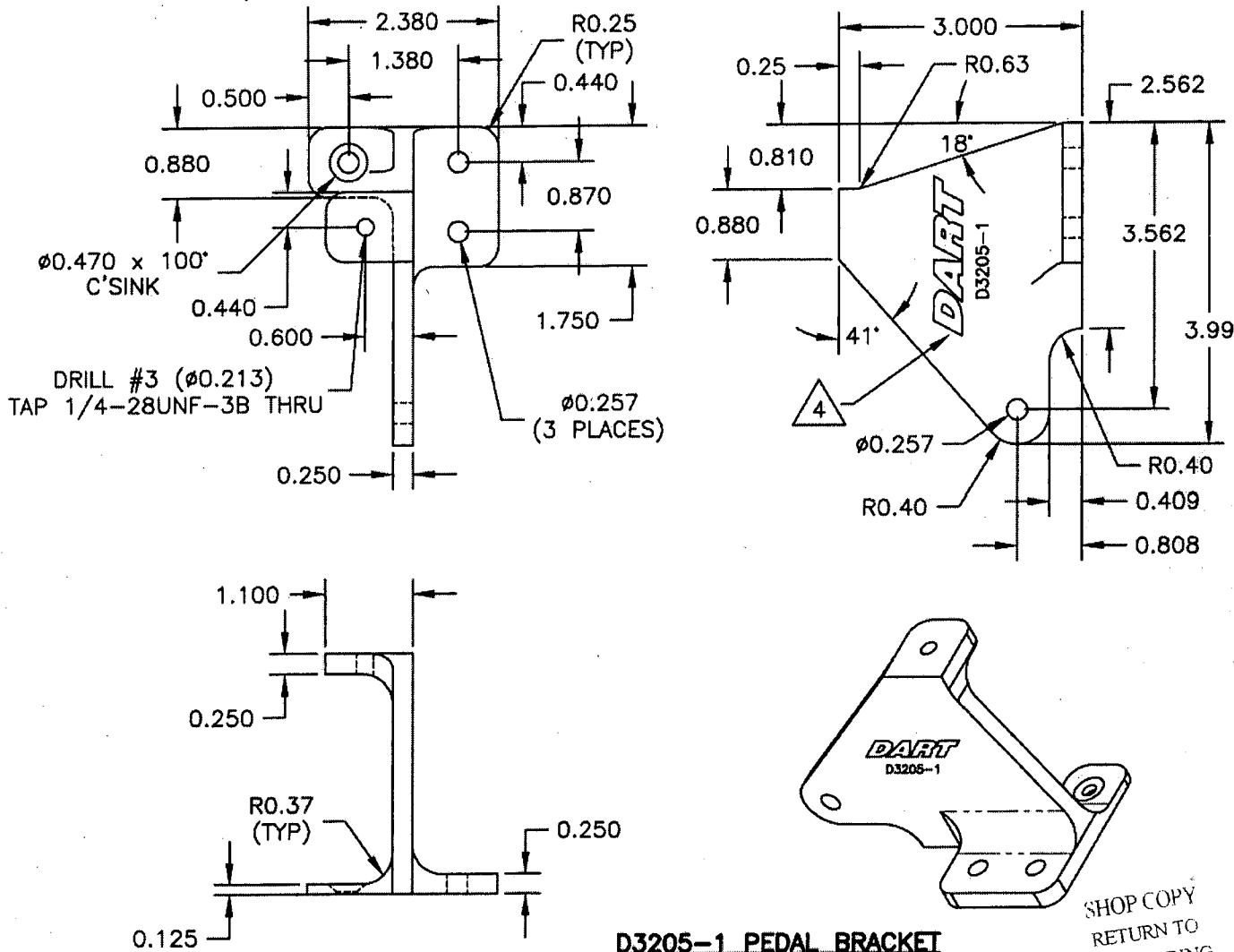
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3205	SHEET 1 OF 2
DATE		TITLE	SCALE
04.01.27		BRACKET	1:2
A	04.01.27	NEW ISSUE	

RELEASED
04.04.05**NOTES:**

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 7075-T73 (QQ-A-200/11 OR QQ-A-250/12)
OR 2024-T3 (QQ-A-200/3 OR QQ-A-250/4)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANTEX (REF. 4.3.5.6) PER DART QSI 005^{NQ} 4.3
- 4) ENGRAVE DART P/N & LOGO AS SHOWN
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE INCHES

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
28942

DART AEROSPACE LTD	Work Order:	28942
Description: Back Plate	Part Number:	D3205-3
Inspection Dwg: D3205 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	J.F.	Audited by:	S.D.	Prototype Approval:	N/A
Date:	06/10/22	Date:	06.10.22	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue	KJ/JLM	<i>[Signature]</i>

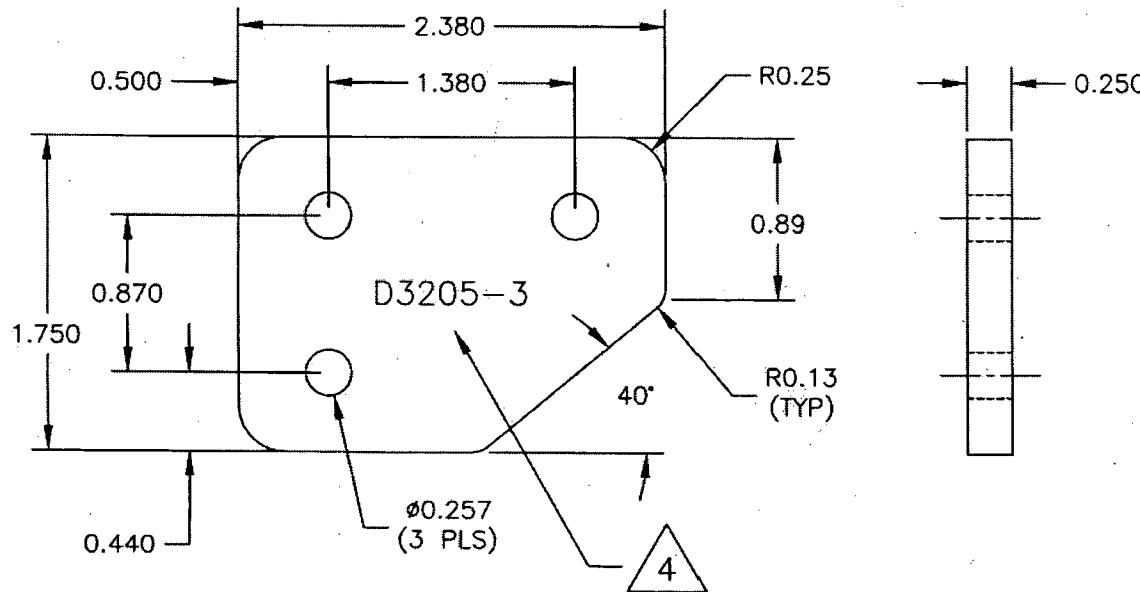
RELEASED

04.04.05

DART



DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA.
CHECKED #	APPROVED #	DRAWING NO. D3205
DATE 04.01.27	TITLE BRACKET	SHEET 2 OF 2 SCALE 1:1



D3205-3 BACK PLATE

NOTES:

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8),
ALUMINUM BAR (M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ENGRAVE DART P/N AS SHOWN
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE INCHES

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WORK ORDER
NO. 28942